Work Orde Friday, September				*106	Z	up we		Page I			
Revision ID:	D3870-041	WD LH		Accept	*N900	040	1100	<u></u> ን* s	Setup Star	1.71	S1*
Start Date: Required Date: Reference:	9/6/2013 9/12/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ! Customer:	ID:				10	.7/
Approvals:	Process Pla	an: <u>M</u> F.	Date: BA-Q Date:	Tooling: SPC (Y/N):		ate:		R	Run Star Stop	1/7	R1* R2*
Sequence ID/ Work Center ID)	Operation Description	<u> </u>	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr						·- <u>-</u>	- -		
D3870	A										•
*100 *100* Large Fab Large Fab		****It is acc	D3870-1 to D3870-3 and veceptable to grind corners to num welding rod batch:	facilitate fitting to the D	3870-1****	— - -		0_	a_	3 <u>-9</u> -1	· · · · ·
110		QC9- Inspect visual per	QSt004- Fusion Welds	0.00				<i>Q</i>	/	/3-9-8	
QC Quality Control		Memo		0.00				0	13-0	γ <u>σ</u> γς. Ο (G . DAS
*120		QC5- Inspect part compl	cteness to step on W/O	0.00				;~	.		JAS
QC Quality Control		Memo		0.00				_0)\3<)	

											DQA:	Date:	· · · · · · · · · · · · · · · · · · ·
NCR: Y	es .	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UPDATE		QA Closed:	Date	:
Mort Orda			<u>.</u>			DISPOSITION			AGAIN	ST DE	PARTMENT	PROCESS	
	Part No. NCR No. Root Desc					Scrap Machining Use-as-is Thermoforming Work Order Update Large Fal			Machining Small Finishi	Finishing Rec/Store/Packaging Supplier			Engineering Quality Other
Root					Descri	ption of work order update	Π	Initial	Action		Sign &		
Cause		Date	Step	Qty	[(or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
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Unapproved			<u> </u>										
						F	AUL	LT CATE	GORY				
Landi	ng Ge	ear				General		-		_	1		"
	E	Bending				Bend		Grain		L	Ovalized	_	Pressure/Forced
		entre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re	\perp	Over/Under	tolerance	Temperature/Cure
		Cracks			L	Broken/Damaged		1 '	on Incomplete	<u> </u>	Part Incorred		Weld
ان ا	∐'	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Unclear	<u> </u>	Part Lost/Mi	ssing	Wrong Stock Pulled
* *		Cuffs				Contamination		Mainte	nance		Part Moved		
	\Box	Heat Trea	it			Countersink		Mislabe	eled	1	Positioned W	/rong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde Friday, Septemb				*106	569*			Page 2	
Item ID: Revision ID: Item Name:	D3870-041 Hardpoint, FW	'D LH		Accept	*N900040	100*	Setup Start Stop	*NS1* *NS2*	
Start Date: Required Date: Reference:	9/6/2013 9/12/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:			14. 17	
Approvals:	Process Plan	n:	Date:	Tooling: SPC (Y/N):	Date:		Run Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center II)	Operation Description Chemical Conversion Co	vat per OSI005 4-1	Set Up/ Run Hours	Tool ID Tool #	Plan Acce Code Qty	•	Reject Insp. Number Stamp	
130 HandFinish Hand Finishing		Мето	A per 201002 4.1	0.00		_1 .	The	13910	
*140 *140* QC Quality Control		QC3- Inspect Part Finish Memo		0.00 DAS 0.00 27 9-89 3 9 10					
150 *150 Packaging		Identify as per dwg & Sto	ock Location:	0.00		_	(

PPP 106541

Memo

Packaging

												DQA:	Da	ate:	
NCR:	/es	/ No				WORK ORDER NON-	COI	NFORN	AANCE / UP	PDATE			-		
									<u></u>	<u>:</u>	_	QA Closed:	Da	ate:	
Work Orde	~~.					DISPOSITION		[AGAINST D	ΕP	ARTMENT,	/PROCESS		
WORK OTUR	=1-					Rework	7	Ī	Skid-tube	Crosstube	7		Water Jet	: [Engineering
Part N	No.					Scrap	1		Machining	Small Fab	7	Pro	d. Eng. Coor.	\vdash	Quality
	-					Use-as-is	1		noforming	Finishing	7	Rec/Stor	re/Packaging		Other
NCR N	No. ِ					Work Order Update]		Large Fab	Composite			Supplier		
Root		<u> </u>			Descri	ption of work order update		Initial	Ad	ction	T	Sign &		-	
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Desc	cription	1	Date	Verification	n	QC Inspector
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		Bending				Bend		Grain			ا_	Ovalized		L	Pressure/Forced
		Centre N	ot Conce	ntric to O	/S	BOM/Route		Hardwa	re	<u>L</u>	_[Over/Under	tolerance		Temperature/Cure
	П	Cracks			·	Broken/Damaged		Inspecti	on Incomplete		ال	Part Incorred	ct		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete,	/Unclear	_]	Part Lost/Mi	ssing		Wrong Stock Pulled
	\Box	Cuffs				Contamination		Mainte	nance			Part Moved			
		Heat Trea	at			Countersink		Mislabe	led			Positioned V	Vrong		_
	П	Inspectio	n Strip in	Tube	-	Cut Too Short		Misread	ļ			Power Loss/	Surge		Other
	П	Ripples in	ı Bend			Drill Holes		Offset	•	_					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Work Ord Friday, Septem								Pag	e 3;				
Item ID: Revision ID: Item Name:	D3870-041 Hardpoint, F	WD LH		Accept	*N900	040	100)*	Setup	Start Stop	17	S1* S2*	
Start Date: Required Date Reference:	9/6/2013 : 9/12/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:							
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):	Date: Date:				Run	Start Stop	17	*NR1* *NR2*	
Sequence ID/ Work Center I 160	D	Operation Description	Work Order Date	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty	ject	Reject Number	Insp. Stamp	r—- }
160		QC21- Final Inspection - Memo	WOLK OFUET REJEASE	0.00						13/	3/11	#	-

Quality Control

MB. Orll

									DQA:	Date	::
NCR: Y	'es / No				WORK ORDER NON-C	ONFOR	MANCE / UP	PDATE	QA Closed:	Date	::
Mork Ordo					DISPOSITION			AGAINST DE		•	·····
Work Orde Part N NCR N	lo			 	Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite				-4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		-		Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desc	cription	Date	Verification	QC Inspector
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Landir	ng Gear				General	_		<u> </u>	_	_	_
į	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hardv	/are	<u></u>	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspec	tion Incomplete	_	Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	Instru	ctions Incomplete,	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
[Cuffs				Contamination	Main	tenance		Part Moved		
	Heat Trea	at			Countersink	Mislat	peled		Positioned V	Vrong	_
	Inspection	n Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	'Surge	Other
ſ	Rinnles in	Rend			Drill Holes	Offset		_			

Out of Calibration
Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio Friday, September 06, 2013 1:33:56 PM

Work Order ID:

106569

Parent Item:

D3870-041

Parent Item Name:

Hardpoint, FWD LH

Start Date: 9/6/2013

Required Date: 9/12/2013

Page 1

Start Qty: 1.00

Required Qty: 1.00

Co	m	m	ents:	
_		~		
-				

IPP Rev:A 09-01-20 as per prelim issue DD verified by:ec

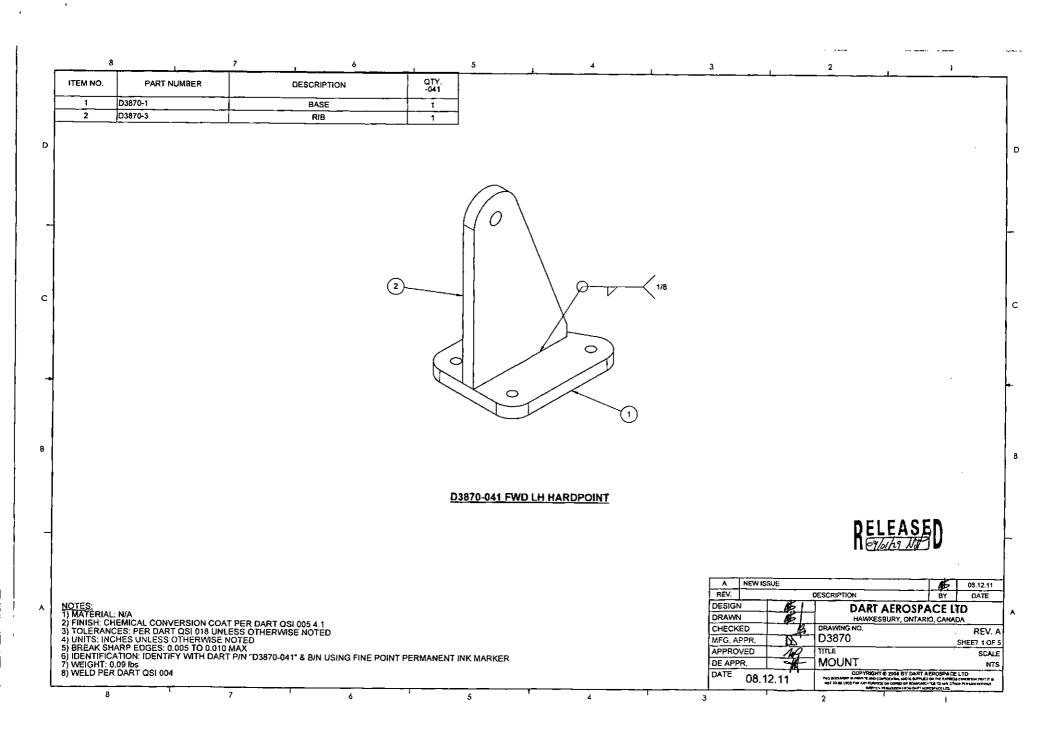
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3870-1 Base		Manufactured	No			100	Each	2.0000	1	$\frac{1}{2}$	13-9-9	· • ·	
D3870-3 Rib		Manufactured	No	Location WA002 449	58	Loc Oty 2 2 100 Loc Oty	Each	c Code 2.0000	1	<u> </u>	L3 =8=_9		
				WA004	59)	2				_			

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WORK OPDER NON-CONFORMANCE / HIDDATE

DQA: _____Date: ____

NCR: 1	es / NO				WORK ORDER NOIV-	JON		VIANCE / OF	DAIL	QA Closed:	Dat	te:
Work Orde	r:				DISPOSITION							
	0				Rework Scrap		Skid-tube Crosstube Machining Small Fab			-1	Water Jet d. Eng. Coor.	Quality
NCR N	lo				Use-as-is Work Order Update]		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	_
Root				Descri	ption of work order update		nitial	Act	tion	Sign &	·	
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[Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorrec	:t	Weld
	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/I	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			[Contamination		Mainte	nance		Part Moved		
	Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	j		Power Loss/	Surge [Other
	Ripples in	Bend			Drill Holes		Offset					
	Torque W	/aves in E	xtrusio	n [Drawing		Out of (Calibration				···
ĺ	Turning S	equence			Finish		Out of S	Sequence				
	Wave/Tw	ist in Tub	e		Folio		Outside	Dimensions				



											DQA:	Date:	, 			
NCR:	⁄es	/ No				WORK ORDER NON-C	ON	FORM	MANCE / UPI	DATE	QA Closed:	Date:				
Mork Ord		_				DISPOSITION				AGAINST DE	T DEPARTMENT/PROCESS					
Work Orde	=1.					Rework	ıl		Skid-tube	Crosstube	1	Water Jet	Engineering			
Part I	۱o. ₋					Scrap		F	Machining	Small Fab Finishing		d. Eng. Coor.	Quality Other			
NCR I	No		···			Use-as-is Work Order Update			oforming Large Fab	Composite	Rec/Stor	Supplier	ouler			
Root				·	Descri	ption of work order update	In	itial	Act	ion	Sign &					
Cause	1	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Descr	ription	Date	Verification	QC Inspector			
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Setup				i '			}				İ					
Other																
Process				}					l L							
Supplier							1		i.							

Landing Gear General Pressure/Forced Bend Grain Ovalized Bending BOM/Route Hardware Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Cracks Broken/Damaged Inspection Incomplete Part incorrect Weld Wrong Stock Pulled Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Burrs Cuffs Contamination Maintenance Part Moved Positioned Wrong Mislabeled Heat Treat Countersink Other Misread Power Loss/Surge Inspection Strip in Tube Cut Too Short Drill Holes Ripples in Bend Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence

Outside Dimensions

FAULT CATEGORY

Wave/Twist in Tube

Folio

Training Unapproved

5 3 QTY. -042 ITEM NO. PART NUMBER DESCRIPTION D3870-1 BASE 1 2 D3870-3 RIB D 0 D3870-042 FWD RH HARDPOINT NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3870-042" & B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.09 ibs
8) WELD PER DART QSI 004 DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D3870 MFG, APPR. SHEET 2 OF 5 APPROVED TITLE SCALE DE APPR. MOUNT NTS COPYRIGHT ID 2008 BY DART AEROSPACE LTD
THIS COMMENT'S PRIVATE AND COMPANYING AN OF BUMENT OF THE BU DATE 08.12.11

3

8

NCR:	Yes	7	No

												DQA:	Date:	•			
NCR:	CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:																
DISPOSITION										AGAINST DEPARTMENT/PROCESS							
Vork Orde	er:						DISPOSITION				AQAM31 DE						
Part No.							Scrap Machining Small Fab. Use-as-is Thermoforming Finishing				Crosstube Small Fab Finishing Composite	Water Jet Engineering Prod. Eng. Coor. Quality Rec/Store/Packaging Other Supplier					
Root					Desci	riptio	on of work order update		nitial	Acti	ion	Sign &					
Cause		Date	Step	Qty		•	Non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector			
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		Bending				_	end ONA/Rausta	_	Grain			Ovalized Over/Under	+-lorones	Pressure/Forced Temperature/Cure			
		Centre Not Concentric to O/S BOM/Route Cracks Broken/Damaged					Hardware			Part Incorred	-	Weld					
	├	Cracks	:		-	_			<u> </u>	on Incomplete ions Incomplete/U	inclose	Part Lost/Mi		Wrong Stock Pulled			
	\vdash	Crushed/0	rimpea		<u> -</u>	_	urrs	<u> </u>	Mainte	•		Part Moved	53111g	J WYONG STOCK Fulled			
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	-	Inspection		Tube	<u> </u>	_	ountersink ut Too Short	\vdash	Misread		 	Power Loss/	_	Other			
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	\vdash	Torque W		xtrusio	n t	_	rawing	\vdash	4	Calibration		-					
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		Turning Sequence Finish Wave/Twist in Tube Folio							Outside Dimensions								

0 D Đ - 0.91 -R0.02 Ø0.204 TYP 4 PL R0.38 TYP 1.842 2.59 0.31+0.03 1.088 Ç 1.00 0.375 0.26+0.03 2.07 0.250 REF

D3870-1 BASE

NOTES: 1) MATERIAL: 6061-T6 (OR 5061-T62) ALUMINUM SHEET 0.25 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.250)

OR AMS 4025 OR AMS 4027 (REF DART SPEC M60
2) FINISH: N/A
3) TOLERANCES. PER DART QSI 0.18 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A

7) WEIGHT: 0.04 lbs

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3870 MFG. APPR. SHEET 3 OF 5 APPROVED TITLE SCALE DE APPR. MOUNT NTS COPYRIGHT # 2006 BY DART AEROSPACE LTD

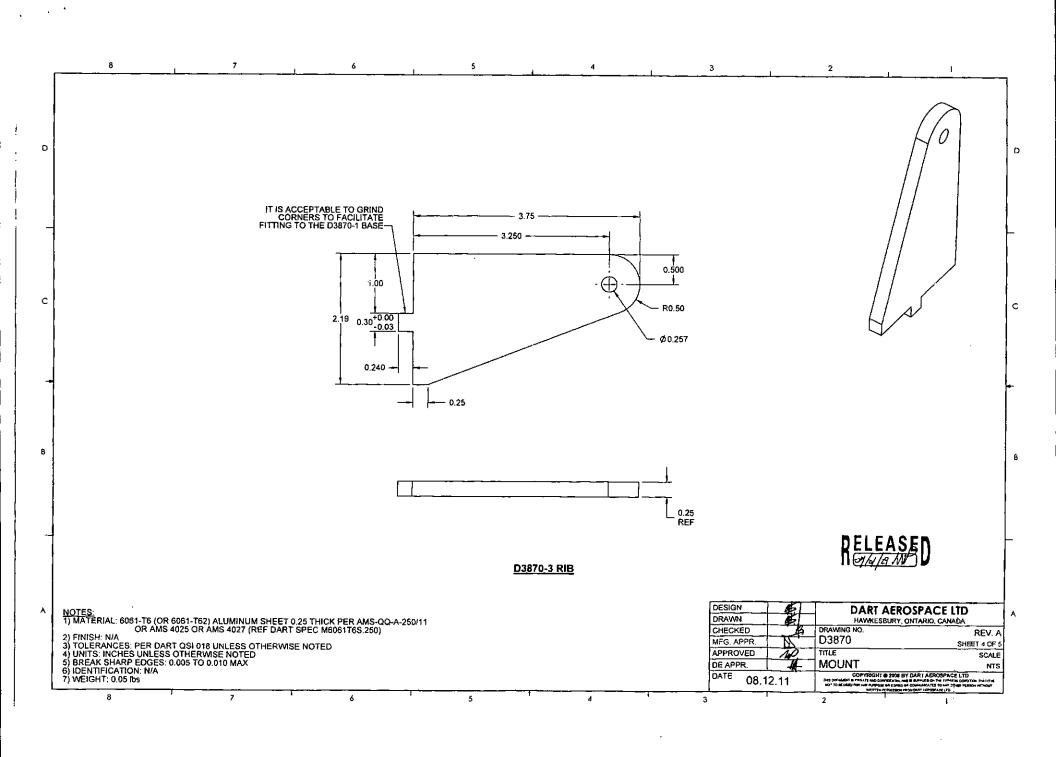
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NCR:	Yes	1	No
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NCR:	•											OA Clasade	Data			
			-			_					QA Closed:	Date	;; 			
Vork Ord	er:						DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS			
							Rework]		Skid-tube	Crosstube	1	Water Jet	Engineering		
Part I	١o.						Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
	•						Use-as-is]	Therr	noforming	Finishing	Rec/Stor	e/Packaging	Other		
NCR I	۷o.		 -				Work Order Update]		Large Fab	Composite]	Supplier]		
Root	-		1		Des	Crir	otion of work order update		initial	Actio	n	Sign &				
Cause	İ	Date	Step	Qty	003		r Non-conformance	1	ief Eng	Descrip		Date	Verification	QC Inspector		
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		Bending					Bend		Grain		<u> </u>	Ovalized	<u></u>	Pressure/Forced		
	L	Centre Not Concentric to O/S					BOM/Route	L	Hardwa	ire	_	Over/Under tolerance		Temperature/Cure		
	_	Cracks Broken/Damaged					<u>_</u>	4 .	ion Incomplete	<u> </u>	Part Incorrect		Weld			
	L	Crushed/Crimped Burrs					_	1	tions Incomplete/Und	clear	Part Lost/Missing Wrong Stock Pulle					
	L	Cuffs					Contamination		Mainte		<u> </u>	Part Moved				
	L	Heat Trea	et .			L.	Countersink	L	Mislabe		<u></u>	Positioned V		_		
	L	Inspection	n Strip in	Tube			Cut Too Short	<u></u>	Misread	d	L_	Power Loss/:	Surge	Other		
	L_	Ripples in	Bend				Drill Holes	L_	Offset							
		Torque W	Vaves in E	Extrusio	n		Drawing	L	Out of	Calibration						
		Turning Sequence Finish							Out of	Out of Sequence						

Outside Dimensions

Wave/Twist in Tube

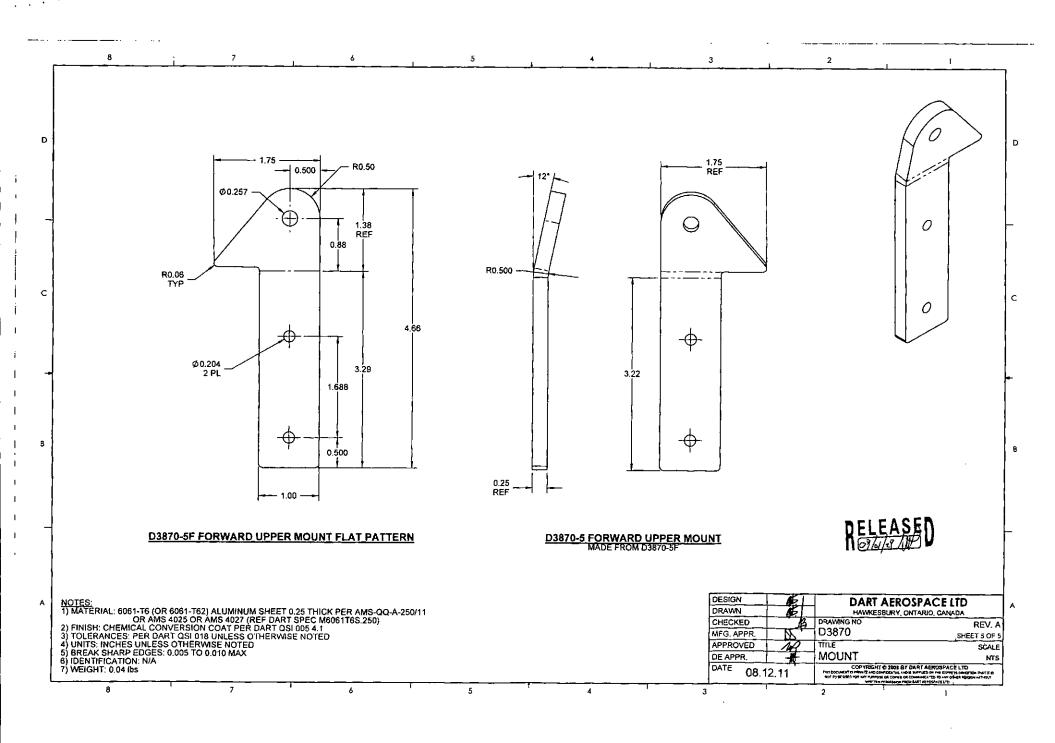


NCR:	Yes	1	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	
Closed:	Date:	

											QA Closed:	Da	te:	
Work Order: DISPOSITION								AGAINST DEPARTMENT/PROCESS						
Part No						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstu Machining Small F Thermoforming Finishi Large Fab Compos			Prod. Eng. Coor. Qu			Engineering Quality Quality Other
Root					Descri	ption of work order update	П	nitial	Act	tion	Sign &			-
Cause	ĺ	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	n	QC Inspector
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Equip/Tooling							1				ı		-	
Operator]	•									
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	-	Bending			_	Bend	Grain			-	Ovalized Pressure/Forced			-
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}	-	Cuffs			\vdash	=	\vdash	Mislabe		<u> </u>	Positioned V	Mrong		
 		Heat Treat Inspection Strip in Tube				Countersink Cut Too Short	\vdash	Misrea		}	Power Loss/	-	\Box	Other
	_	Ripples in	•	iupe	-	Drill Holes	\vdash	Offset		<u> </u>	Trower ross	2018c	_ [Janet .
1	_	Torque W		:vtrucio	ຸ ├-	Drawing	\vdash	Į.	Calibration					
1		Turning S			'' 	Finish	_	1	Sequence			· <u>-</u> -		
1 +		_	•		-	Folio	-	1						
L		Wave/Twist in Tube Folio						Outside Dimensions						



											DQA	۱: Date	e:	
NCR:	Yes	/ No				WORK ORDER NON-CONFORMANCE / UPDATE								
		<u>-</u>							- · <u>-</u>	·_	QA Closed	l: Date	<u> </u>	
Work Orde	0 F-				İ	DISPOSITION		}		AGAINST DI	EPARTMEN	T/PROCESS		
WORK OIG	C1.					Rework	ገ ,	į	Skid-tube	Crosstube	7 -	Water Jet	Engineering	
Part N	۷n					Scrap	┪ .		Machining	Small Fab	Pr	od. Eng. Coor.	Quality	
10111	٠٠.					Use-as-is	1		noforming	Finishing		ore/Packaging	Other	
NCR I	No.					Work Order Update	1		Large Fab	Composite	1	Supplier	1 1	
										<u> </u>	-			
Root		_			Descri	ption of work order update		Initial	Act	tion	Sign &	7		
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Desc	ription	Date	Verification	QC Inspector	
Doc/Data	Ш		ļ									•		
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Landi	ing (ear			_	General	,_	٠.			=	_	_	
}	L	Bending			L	_Bend	L	Grain			Ovalized	L	Pressure/Forced	
·	L	Centre N	ot Conce	ntric to (o/s	BOM/Route	L	Hardwa	re		Over/Unde	er tolerance	Temperature/Cure	
ļ	L	Cracks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorr	ect	Weld	
1		Crushed,	Crimped			Burrs		Instructi	ions Incomplete/	Unclear	Part Lost/N	/lissing	Wrong Stock Pulled	
		Cuffs				Contamination		Mainte	nance		Part Move	d		
		Heat Tre	at			Countersink		Mislabe	led		Positioned	Wrong	_	
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss	s/Surge	Other	
1		Ripples in	n Bend			Drill Holes		Offset		_				

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish